

Work Order ID 76885-2

76885

Page 1

November-22-11 3:24:26 PM

Item ID: D139-799-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cargo Door Hinge

Start Date: 22/11/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/12/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/22 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9567

A

IIN-D139-799

E

100

WSP

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D139-799-013
CHG003

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12-01-10 (5)
for M.L.J 11-12-1 (10)

11/21/11 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76885

November-22-11 3:24:26 PM

76885

Page 2

Item ID: D139-799-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Door Hinge

Start Date: 22/11/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/12/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

12-01-10 (5)

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D139-799-013

Location: 3
PPP rev: B

12/11/11 (5)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/11/12
ME
12-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 1

Work Order ID: 76885

76885

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A 10.06.08 new issue DD verf:JLM
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD
IPP REV:C AS PER DSI9567 revA 11.10.17 DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2585
D2585
Mounting Channel

Manufactured No

110

Each

80.0000

1

10

**

Location

Loc Qty

Loc Code

ST017

80

73297

14

74488

66

Manufactured No

110

Each

87.0000

1

10

**

Location

Loc Qty

Loc Code

ST204

87

73296

47

74489

40

Manufactured No

110

Each

24.0000

1

10

**

D2621
D2621
Latch Plate, 350 Spacepod

Location

Loc Qty

Loc Code

ST019

24

73304

24

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 76885

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 10.00

Required Qty: 10.00

D3552-23

Manufactured No

110 Each

29.0000

1

10

D3552-23

Door Prop

**

Location

Loc Qty

Loc Code

ST272A

29

74847

9

76340

20

Manufactured No

110 Each

0.0000

1

10

D3622-1

D3622-1

Ball Stud

**

D3622-3

Manufactured No

110 Each

15.0000

1

10

D3622-3

Ball Stud

**

Location

Loc Qty

Loc Code

ST070

15

53951

4

72103

11

Manufactured No

110 Each

10.0000

2

20

D4072-1

D4072-1

Airframe Hinge

**

Location

Loc Qty

Loc Code

ST120

10

74241

10

Manufactured No

110 Each

25.0000

2

20

D4072-3

D4072-3

Airframe Hinge Backing Plate

**

Location

Loc Qty

Loc Code

ST120

25

74270

25

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 76885

76885

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 10.00

Required Qty: 10.00

D4072-5

D4072-5

Bushing

Manufactured No

110 Each

23.0000

4 40

**

172

B 76943

Location

Loc Qty

Loc Code

ST120

23

74268

23

Manufactured No

110 Each

10.0000

2 20

**

23

B 76888

Location

Loc Qty

Loc Code

ST120

10

72107

10

Manufactured No

110 Each

35.0000

2 20

**

10

B 76888

D4073-3

D4073-3

Door Hinge Backing Plate

D4074-1

D4074-1

Bracket

Manufactured No

110 Each

38.0000

1 10

**

20

11/12/11

Location

Loc Qty

Loc Code

ST120

38

74494

14

76338

24

10

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 76885

76885

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 10.00

Required Qty: 10.00

D4074-3

Manufactured No

110 Each

26.0000

1

10

**

D4074-3

Channel

Location

Loc Qty

Loc Code

ST120

26

72110

26

10

Manufactured No

110 Each

118.0000

1

10

**

D4074-5

D4074-5

Backing Plate

Location

Loc Qty

Loc Code

ST120

118

74495

96

76339

22

10

Manufactured No

110 Each

14.0000

1

10

**

D4074-7

D4074-7

Striker Plate

Location

Loc Qty

Loc Code

ST120

14

75624

14

8

B76887

24

12/11/4

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 76885

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

76885

D139-799-013

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

110

Each

8,284.000

20

200

MS21042L3

Nut

**

11/12/15

Location

Loc Qty

Loc Code

ST300

213

117441

16

117885

35

118451

5

118927

157

ST516

5994

119017

5994

ST518

2077

119075

2077

MS21042L5

Purchased

No

110

Each

2,254.000

1

10

MS21042L5

Nut

**

200

SP

Location

Loc Qty

Loc Code

ST300

754

116105

5

116548

43

117611

52

118179

496

118910

158

ST518

1500

119109

1500

MS27039-1-10

Purchased

No

110

Each

127.0000

8

80

MS27039-1-10

Screw

**

11/12/15 SP

(10)

Location

Loc Qty

Loc Code

ST291

127

119307

77

119531

50

72

8

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 76885

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

76885

D139-799-013

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 10.00

Required Qty: 10.00

MS27039-1-14

Purchased

No

110

Each

46.0000

2

20

**

MS27039-1-14

Screw

Location

Loc Qty

Loc Code

MEZZ

46

112312

46

110

Each

24.0000

8

80

**

MS27039-1-16

Purchased

No

MS27039-1-16

Screw

Location

Loc Qty

Loc Code

ST291

24

118612

24

110

Each

67.0000

1

10

**

MS27039-1-17

Purchased

No

MS27039-1-17

Screw

Location

Loc Qty

Loc Code

ST292

67

117591

67

110

Each

3,976.000

18

180

**

NAS1149D0363J

Purchased

No

NAS1149D0363.I

Washer

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

960

117601

148

118077

1

118612

55

118968

756

November-22-11 3:24:32 PM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 76885

76885

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0663I

Purchased

No

110

Each

2,486.000

1

10

NAS1149D0663.I

Washer

**

Location

Loc Qty

Loc Code

ST407

2486

119075

2486

110

Each

74.0000

4

40

NAS1515H5I

Purchased

No

*NAS1515H5I *

WASHER

**

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

34

118614

24

119309

10

1109902 11/12/13

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-799 REV. E AND ICA-D139-799 REV. 4
REF. FAA STC: SR02138SE

PURPOSE:

THE PURPOSE OF THE DART SERVICE INSTRUCTION (DSI) IS TO CHANGE THE P/N OF THE DOOR PROP USED IN D139-799-013 CARGO DOOR FWD OPENING HINGE KIT FROM D3552-13 TO D3552-23 TO PREVENT THE MODIFIED DOOR FROM HITTING THE MAINTENANCE STEP IN THE DOWN POSITION

PARTS LIST CHANGE:

FOR D139-799-013 AT CHG 003 AND SUBSEQUENT, THE PARTS LIST SHOULD BE CHANGED AS FOLLOWS:

5.0 D139-799-013 Cargo Door Hinge Kit (IIN-D139-799 Rev. E)

52.4 D139-799-013 Cargo Door Hinge Kit (ICA-D139-799 Rev. 4)

QTY. -013	PART NUMBER	DESCRIPTION
X	D139-799-013	CARGO DOOR HINGE KIT

IS:

1	D3552-23	DOOR PROP
---	----------	-----------

WAS:

1	D3552-13	DOOR PROP
---	----------	-----------

CUSTOMERS WHO HAVE RECEIVED D139-799-013 AT CHG 002 OR EARLIER CAN OBTAIN THE DSI 9567-011 DOOR PROP KIT FROM DART

QTY -011	PART NUMBER	DESCRIPTION
X	DSI9567-011	DOOR PROP KIT
1	D3552-23	DOOR PROP

PROCEDURE:

REMOVE D3552-13 DOOR PROP AND REPLACE WITH D3552-23 DOOR PROP PER CHAPTER 52 OF ICA-D139-799.

WEIGHT AND BALANCE:

NEGLIGIBLE EFFECT ON WEIGHT AND BALANCE ASSOCIATED WITH THIS CHANGE

A	NEW ISSUE	RF	11.09.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD KENT, WA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9567	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR PROP CHANGE	NTS
DATE	11.09.27	COPYRIGHT © 2011 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-13	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-799 REV. E AND ICA-D139-799 REV. 4
REF. FAA STC: SR02138SE

REFERENCE ONLY

PURPOSE:

THE PURPOSE OF THE DART SERVICE INSTRUCTION (DSI) IS TO CHANGE THE P/N OF THE DOOR PROP USED IN D139-799-013 CARGO DOOR FWD OPENING HINGE KIT FROM D3552-13 TO D3552-23 TO PREVENT THE MODIFIED DOOR FROM HITTING THE MAINTENANCE STEP IN THE DOWN POSITION

PARTS LIST CHANGE:

FOR D139-799-013 AT CHG 003 AND SUBSEQUENT, THE PARTS LIST SHOULD BE CHANGED AS FOLLOWS:

5.0 D139-799-013 Cargo Door Hinge Kit (IIN-D139-799 Rev. E)

52.4 D139-799-013 Cargo Door Hinge Kit (ICA-D139-799 Rev. 4)

QTY. -013	PART NUMBER	DESCRIPTION
X	D139-799-013	CARGO DOOR HINGE KIT

IS:

1	D3552-23	DOOR PROP
---	----------	-----------

WAS:

1	D3552-13	DOOR PROP
---	----------	-----------

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QTY -011	PART NUMBER	DESCRIPTION
X	DSI9567-011	DOOR PROP KIT
1	D3552-23	DOOR PROP

PROCEDURE:

REMOVE D3552-13 DOOR PROP AND REPLACE WITH D3552-23 DOOR PROP PER CHAPTER 52 OF ICA-D139-799.

WEIGHT AND BALANCE:

NEGLIGIBLE EFFECT ON WEIGHT AND BALANCE ASSOCIATED WITH THIS CHANGE

A	NEW ISSUE	RF	11.09.27
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DESIGN	RF	DART AEROSPACE LTD KENT, WA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9567	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR PROP CHANGE	NTS
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